

is three-sixteenths of an inch or greater. The annular clearance of socket joints shall be held to small clearances which experience indicates is satisfactory for the brazing alloy to be employed, method of heating, and material to be joined. The annular clearance shall be shown on drawings submitted for approval of socket joints.

(2) Copper pipe fabricated with longitudinal joints for pressures not exceeding that permitted by the regulations in this subchapter may have butt, lapped, or scarfed joints. If of the latter type, the kerf of the material shall be not less than 60°.

(c) *Brazing, general.* (1) Heat shall be applied evenly and uniformly to all parts of the joint in order to prevent local overheating.

(2) The members to be joined shall be held firmly in place until the brazing alloy has set so as to prevent any strain on the joint until the brazing alloy has thoroughly solidified. The brazing shall be done by placing the flux and brazing material on one side of the joint and applying heat until the brazing material flows entirely through the lap and shows uniformly along the seam on the other side of the joint. Sufficient flux shall be used to cause the brazing material to appear promptly after reaching the brazing temperature.

Subpart 56.80—Bending and Forming

§ 56.80-5 Bending.

Pipe may be bent by any hot or cold method and to any radius which will result in a bend surface free of cracks, as determined by a method of inspection specified in the design, and substantially free of buckles. Such bends shall meet the design requirements of 102.4.5 and 104.2.1 of ASME B31.1 (incorporated by reference; see 46 CFR 56.01-2). This shall not prohibit the use of bends designed as creased or corrugated. If doubt exists as to the wall thickness being adequate, Class I piping having diameters exceeding 4 inches shall be nondestructively examined by the use of ultrasonics or other acceptable method. Alternatively, the pipe may be drilled, gaged, and fitted with a screwed plug extending outside

the pipe covering. The nondestructive method shall be employed where the design temperature exceeds 750 °F. Prior to the use of nondestructive method of examination by the above procedure, it shall be demonstrated by the user, in the presence of a marine inspector on specimens similar to those to be examined, that consistent results, having an accuracy of plus or minus 3 percent, can be obtained.

[CGFR 68-82, 33 FR 18843, Dec. 18, 1968, as amended by CGFR 69-127, 35 FR 9979, June 17, 1970; USCG-2003-16630, 73 FR 65185, Oct. 31, 2008]

§ 56.80-10 Forming (reproduces 129.2).

(a) Piping components may be formed (swaging, lapping, or upsetting of pipe ends, extrusion of necks, etc.) by any suitable hot or cold working method, providing such processes result in formed surfaces which are uniform and free of cracks or other defects, as determined by methods of inspection specified in the design.

§ 56.80-15 Heat treatment of bends and formed components.

(a) Carbon-steel piping that has been heated to at least 1,650 °F (898 °C) for bending or other forming requires no subsequent heat treatment.

(b) Ferritic alloy steel piping which has been heated for bending or other forming operations shall receive a stress relieving treatment, a full anneal, or a normalize and temper treatment, as specified by the design specification before welding.

(c) Cold bending and forming of carbon steel having a wall thickness of three-fourths of an inch and heavier, and all ferritic-alloy pipe in nominal pipe sizes of 4 inches and larger, or one-half-inch wall thickness or heavier, will require a stress-relieving treatment.

(d) Cold bending of carbon-steel and ferritic-alloy steel pipe in sizes and wall thicknesses less than specified in 129.3.3 of ASME B31.1 (incorporated by reference; see 46 CFR 56.01-2) may be used without a postheat treatment.

(e) For other materials the heat treatment of bends and formed components must be such as to ensure pipe properties that are consistent with the original pipe specification.